

Work Order ID 53608

November 10, 2009 8:35:29 AM

Page 1

Item ID: D3694-5

Accept

Setup Start

Revision ID:

Stop

Item Name: MOUNTING PLATE ASSY

Start Date: 11/10/09 Start Qty: 10.00

Cust Item ID:

Required Date: 11/16/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3694

C

100

0.00

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3694

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

B 9-11-10

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B 9-11-10

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

11 09 11 10 (10)

Work Order ID 53608

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Page 2

Item ID: D3694-5

Accept

Setup Start

Revision ID:

Stop

Item Name: MOUNTING PLATE ASSY

Start Date: 11/10/09 Start Qty: 10.00

Cust Item ID:

Required Date: 11/16/09 Req'd Qty: 10.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
	Memo	0.00							
	1- Counter sink holes 0.204" (4 places) as per dwg D3694 2- deburr								
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								
150  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							
	Hand Finishing								

SB 09/11/11 (10)

SB 09/11/11 10

SB 09/11/11 (10)

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Setup Start



Revision ID:

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Item Name: MOUNTING PLATE ASSY

Start Date: 11/10/09 Start Qty: 10.00



Cust Item ID:

Required Date: 11/16/09 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

155

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



M112558

⇒ 41

09/11/11

X10

Ø

Powdercoat

Memo

0.00

Powder Coating

POWDER COAT:

Start Time: 1:00pm

Oven Temperature: 320°F

Finish Time: 1:30pm

160

QC3- Inspect Part Finish

0.00



Memo

0.00

QC

Quality Control

MD 09/11/11

X10

170

Identify as per dwg & Stock Location: 255

0.00



Memo

0.00

Packaging

Packaging

9/11/12

SP

1 pc to Russ for HAI

09/11/12

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Item ID: D3694-5

Accept

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Item Name: MOUNTING PLATE ASSY

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Cust Item ID:

Required Date: 11/16/09 Req'd Qty: 10.00

Customer:


Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09/11/13 
MF
09-11-13

Picklist Print

November 10, 2009 8:35:28 AM

Page 1

Work Order ID: 53608

Parent Item: D3694-5RevPRELIM

Parent Item Name: MOUNTING PLATE ASSY

Comments: IPP Rev: C 09-03-18 Powder Coat step added KJ Verified by: EC

Start Date: 11/10/09

Required Date: 11/16/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.125

Purchased

No

100

sf

98.5981

7.1158



11/9-11-10

6061-T6.125 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

98.5981

110062

1.85

111642

19.592

112476

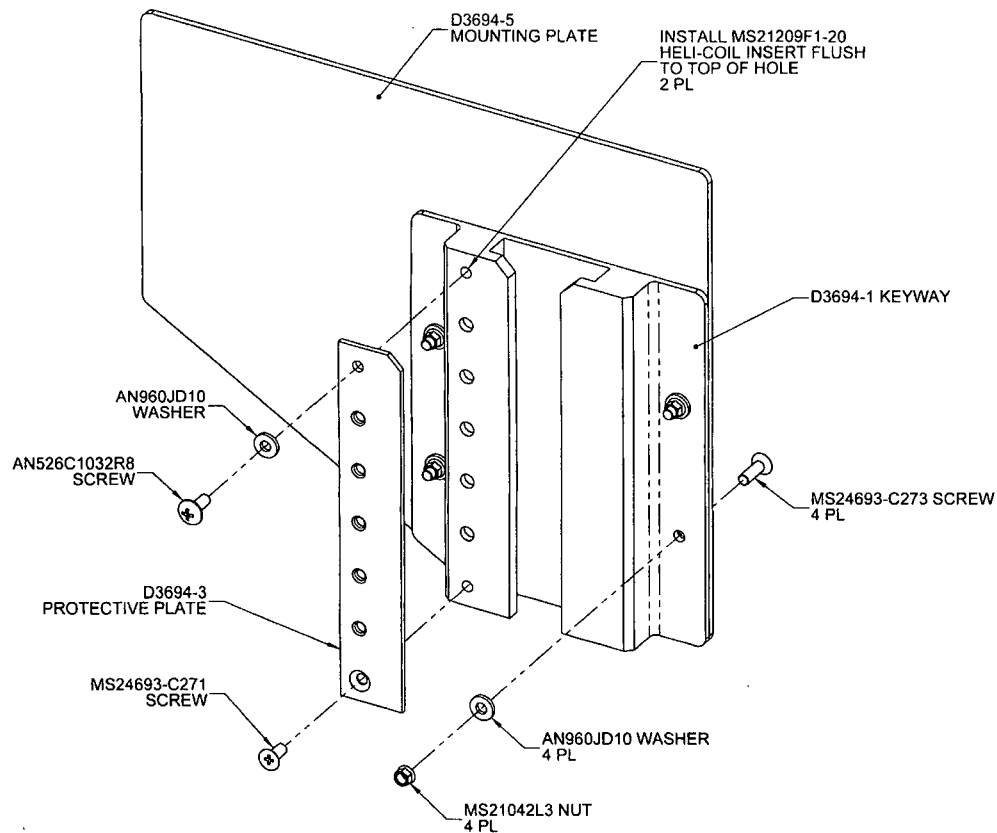
32

112567

45.1561

112567

WLB 53608



D3694-041 MOUNTING PLATE ASSY

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3694-041	MOUNTING PLATE ASSY
11	1	D3694-1	KEYWAY
12	1	D3694-3	PROTECTIVE PLATE
13	1	D3694-5	MOUNTING PLATE
21	1	AN526C1032R8	SCREW
22	5	AN960JD10	WASHER
23	4	MS21042L3	NUT
24	2	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
25	1	MS24693-C271	SCREW
26	4	MS24693-C273	SCREW

RELEASED
09/02/05/MB

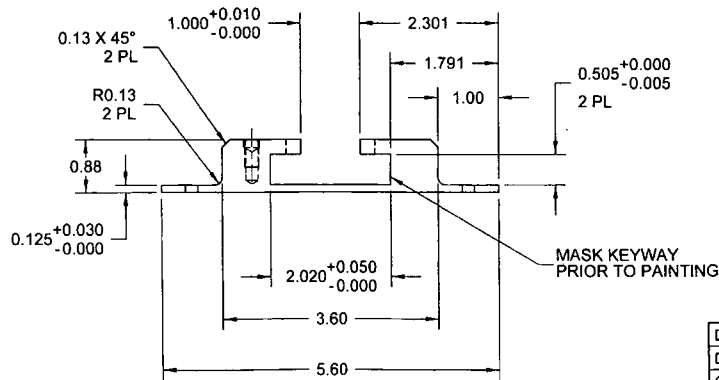
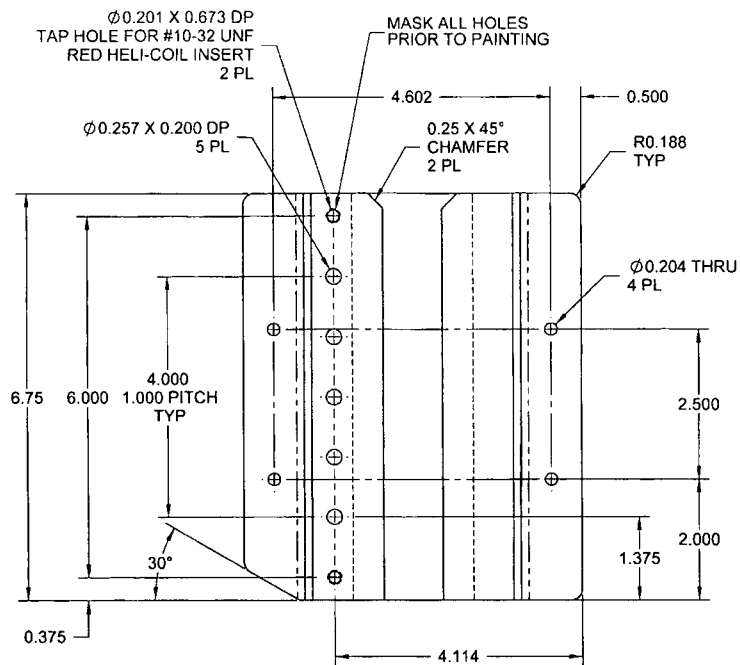
C	REDESIGNED ITEM 11: REVISED ITEM 12: DIM Ø0.204 WAS Ø0.234 (ZN D6-3); ADDED ITEM 13; UPDATED BOM TO CURRENT STANDARDS (ZN D3-1). REASON: ENSURE COMPATIBILITY WITH ELIGIBLE OEM AIRCRAFT POSTS AND ELIMINATE SLOPPY FIT.	MB	08.11.03
B	QTY 1 MS24693-C271 SCREW WAS QTY 2 (ZN D3-1); ADD AN526C1032R8 SCREW AND AN960JD10 WASHER (ZN D3-1, ZN C7-1); 1.18 WAS 1.15 (ZN C7-3); CSK WAS 2 PL (ZN D4-3); 0.810 WAS 0.785 (ZN C3-3). REASON: REDESIGN TO USE AN526 TYPE SCREW HEAD AS SAFETY STOP	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.03		

D3694-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3694-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.70 lbs

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WFO 53608



D3694-1 NOTES:

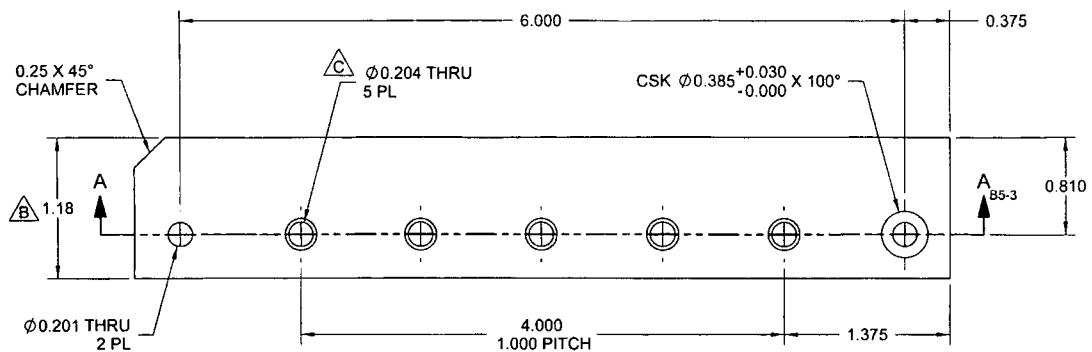
- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.39 lbs

D3694-1 KEYWAY

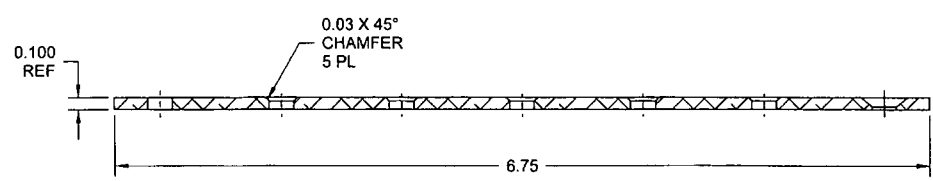
RELEASED
09/05/10

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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D3694-3 PROTECTIVE PLATE



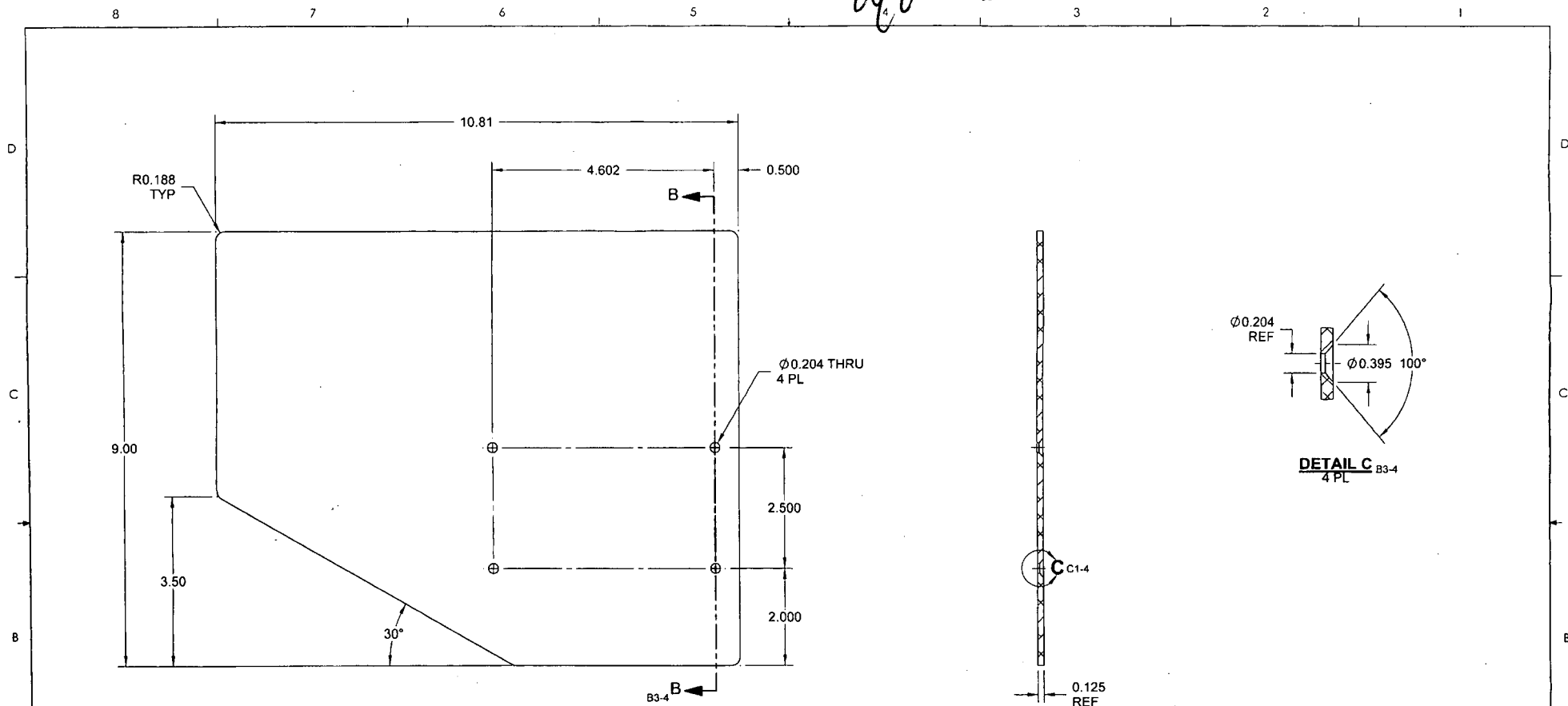
SECTION A-A C3-3

- D3694-3 NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK),
PER PER AMS 5513 OR AMS 5524
REF. DART SPEC. M304S12GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.22 lbs

RELEASED
9/12/05

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MFG. APPR.		D3694	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING PLATE ASSY	NTS
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WFO 53608



D3694-5 MOUNTING PLATE

SECTION B-B B5-4

RELEASED
6/9/05 MB

D3694-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR OR AMS 4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.08 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3694	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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